

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013862**Date Inspected:** 05-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Welding of tower strut ND1-STSA4-6-135M-1-A. The Welding Procedure was identified as WPS-B-T-2212-Tc-U4b. The welders were identified as 044551 and 044541, and found to be certified in the 3G position with the SMAW process. The ZPMC CWI was identified as Yu Dong Ping.

Weld repair of the bottom plate weld of 8AE to 8BE, SEG 044A-043, pursuant to B-CWR 1469. The wps was identified as WPS-345-SMAW-4G(4F). The welder was identified as 048659. The ABF QC present was identified as Yan Bo Jia.

ABF UT technician performing conventional ultrasonic testing, UT, at section 7CW to 7DW, deck plate splice.

Welding of cantilever flange BK001-032-009. The welder was identified as 222396. The WPS was identified as WPS-B-T-2231-Tc-U4b-F. The ZPMC CWI was identified as Liu Hua Jie. The ZPMC QC was identified as Wang Jie. The ABF QC present was identified as Yan Bao Jia.

Welding of tower strut ND1-STSA4-6-139M-1-25, 26. The Welding Procedure was identified as WPS-B-T-2112.

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The welder was identified as 040724 and found to be certified in the 3G position with the SMAW process.
The ZPMC CWI was identified as Yu Dong Ping.

Welding of tower strut ND1-STSA4-6-131M-2-71, 72. The Welding Procedure was identified as WPS-B-T-2112.
The welder was identified as 251194 and found to be certified in the 3G position with the SMAW process.
The ZPMC CWI was identified as Yu Dong Ping.

Welding at section 8BE to 8CE longitudinal diaphragm. This weld is identified as SEG046B-024, 046. The welder was identified as 220069. The welding procedure was identified as WPS-B-T-2232-Tc-U4b-F and WPS-B-T-2233-Tc-U4b-F. The CWI was identified as Liu Hua Jie.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
